

Work Order ID 69287

Friday, May 06, 2011 11:50:16 AM



Page 1

Item ID: D3720-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3720

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

6061.175

B11-5-13

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/11/11

10 units
(+20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	C'sink as per dwg D3720								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

EPH/05/16 20

5/11/16

count
420

13

20x Ø m. 5/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

20

BR 11-5-16.

170



Packaging

Packaging

Identify as per dwg & Stock Location Small-tab

0.00

Memo

0.00

11/5/16 SD 200

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/18 JF

11-05-18

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, May 06, 2011 11:50:22 AM

Page 1

Work Order ID: 69287



Parent Item: D3720-1



Parent Item Name: Step Spacer



Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			100	sf	111.9000	0.085	1.789474			
6061-T6 .125 Sheet													

11-5-13

Location

Loc Qty

Loc Code

MAT021

111.9

113608

87.9

116700

24

113608

60

W/O:		WORK ORDER CHANGES					
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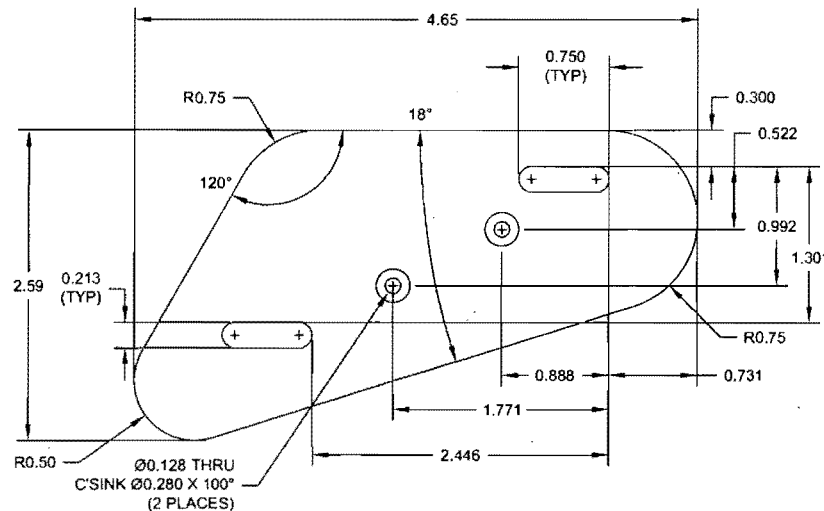
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69287

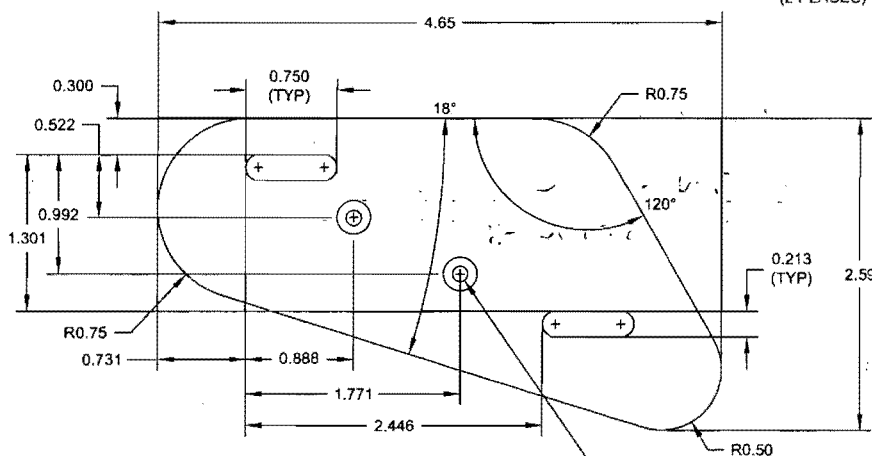
M 11-05-6



D3720-1 STEP SPACER

*628
731
1.629*

RELEASED
06-01-10



D3720-2 STEP SPACER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

A		NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION			BY	DATE
DESIGN	AK	DART AEROSPACE LTD			
DRAWN	BB	HAWKESBURY, ONTARIO, CANADA			
CHECKED	LG	DRAWING NO.	REV. A		
MFG. APPR.	AK	D3720	SHEET 1 OF 1		
APPROVED	AK	TITLE	SCALE		
DE APPR.	AK	STEP SPACER	1:1		
DATE	07.12.27		COPYRIGHT © 2007 BY DART AEROSPACE LTD		
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